

SPL1+-1

Work Order ID 164245-1

164245

BLUE

Page 1

Monday, July 17, 2017 2:28:42 PM

Item ID: D2731-7 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 8/4/2017 Start Qty: 100.00 *100*
 Required Date: 9/25/2017 Req'd Qty: 100.00 *100*
 Reference:

24 JUL 18 2017
 DAS
 13
 9-89

Cust Item ID:
 Customer:

Approvals: Process Plan: 21 9-89 Date: Tooling: Date: Run Start *NR1*
 QC: Date: JUL 17 2017 SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2731	Rev C								DAS 13 9-89
110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1					100		JUL 17 2017	
Outsource5	Memo	18,000.00							
Outsource process - Machining	Issue P/O to Metec : 37085 Machine as per dwg C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	2.00							
Packaging	ENSURE C OF C IS ATTACH.								
130	QC6- All purchased or subcontracted products	0.00							
130									
QC	Memo	0.00							
Quality Control									

24 x 8017-7-19

24 JUL 20 2017
 DAS
 38
 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						(X24)			201708/03
HandFinish	Memo	2.01							BEB
Hand Finishing									
145		0.00							
145						24			2017/08/22
SprayPaint	Memo	0.00							
Spray Painting	PRIME B PO 37518								
	DEFLEET BLUE B								
	DEFLEET CLEAR B								
155	QC3- Inspect Part Finish	0.00							
155									
QC	Memo	0.00							
Quality Control									

received 24x SPA-8-24x 24x 17/09/17

DAS 13 9-00

DAS 36 9-00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>St</u>	0.00							
170						24	1	SEP 07 2017	SP
Packaging	Memo	1.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									17/9/8
QC	Memo	10.00							
Quality Control									

SEP 07 2017

DAS
21
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, July 17, 2017 2:28:48 PM

Page 1

Work Order ID: 164245

164245

Parent Item: D2731-7

D2731-7

Parent Item Name: Mounting Lug

Start Date: 8/4/2017

Required Date: 9/25/2017

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D00.05.19Added inspect level 8, removed P/O powder
coatingEC IPP REV:E 13.06.25
OUTSOURCE METEC DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-7P		Purchased	No			100	Each	0.0000	1	100			
D2731-7P									**				
Lug													
D2423		Manufactured	No			110	f	513.7539	0.0683	7.189474			
D2423									**				
Lug Extrusion													

Location

Loc Qty

Loc Code

Metec

513.7538737

115229

60.356

127892

83.2745647

148835

34.123309

160522

336

24x
24x 8017-7-19
DAS
13
9-80
JUL 17 2017

DQA: _____ Date: _____



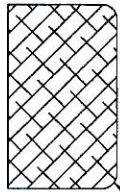
WORK ORDER NON-CONFORMANCE / UPDATE

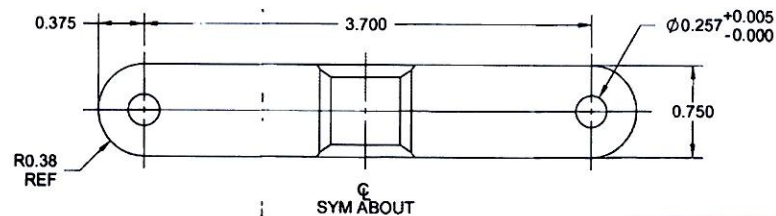
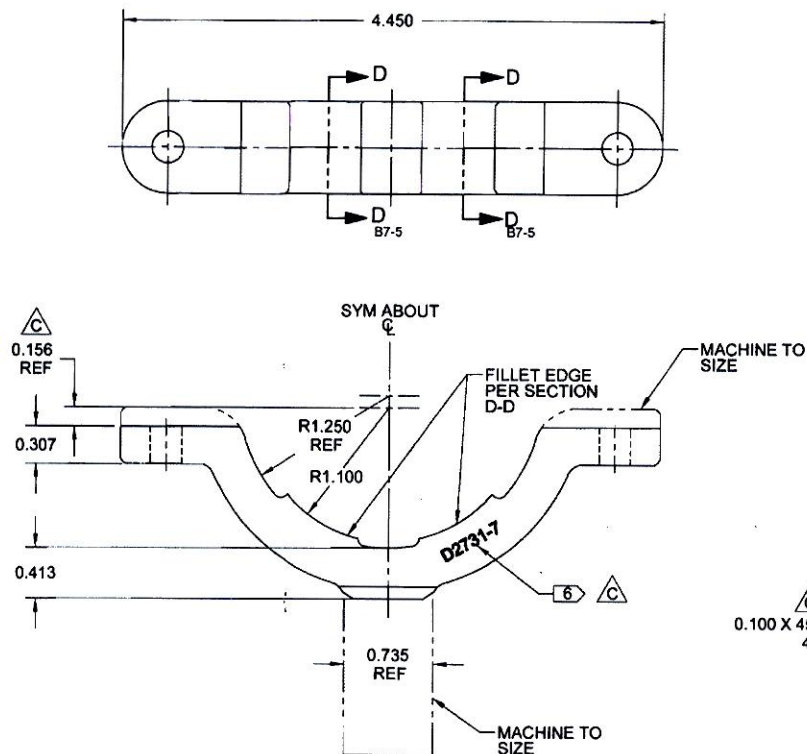
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Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164245 MC5
17-0777


R0.06 MIN-R0.10 MAX
2 PL
SECTION D-D D4-5
SCALE 2X



D2731-7 MOUNTING LUG

DEO ATTACHED
RELEASED
(09/06/25/17)

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37085**

Purchase Order Date 7/17/2017

PO Print Date 7/17/2017

Page Number 1 of 2

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2731-7P AS PER DWG D2731 REV. C B164245 NO PAINT REQUIRED	Lug	8/16/2017 Yes 8/16/2017		100.00 Each	\$15.00	\$1,500.00
						Line Total:	\$1,500.00
2	D3394-3P AS PER DWG D3394 REV. B B162246 NO PAINT REQUIRED	Lug	8/16/2017 Yes 8/16/2017		60.00 Each	\$16.10	\$966.00
						Line Total:	\$966.00

Rec'd 241
SP17-7-19.

DA
38
38

Note:

7/17/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21784
Date: Jul 17, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 37085	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Jul 17, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 Lug, unpainted	Each	100	24	76
D3394-3 Lug, unpainted	Each	60	60	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by <u>SP 17-7-19</u>		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Material Batch #	Paint Batch #	P.O. Number
✓ 24	D2731-7 ✓	Lug	148835	Unpainted	37085
60	D3394-3	Lug	115529	Unpainted	37085

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, July 18, 2017



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37518**

Purchase Order Date 8/22/2017

PO Print Date 8/23/2017

Page Number 4 of 5

Order From :
ATELIER DEBOSSELAGE
358 PRINCIPALE
CALUMET, QC J0V 1B0
CA

VC-ATE001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 819 242 5633

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Diane Baker
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Total: \$225.00

10	162200	D206-667-207BL Aft Crosstube	8/24/2017	1.00	\$225.00	\$225.00
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No
8/24/2017

Prime and Paint Deflect Blue

Line Total: \$225.00

11	164245	D2731-7 Mounting Lug	8/24/2017	24.00	\$18.00	\$432.00
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No
8/24/2017

Prime and Paint Deflect Blue

Line Total: \$432.00

12	164246	D3394-3 Lug	8/24/2017	60.00	\$18.00	\$1,080.00
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No
8/24/2017

Prime and Paint Deflect Blue

Line Total: \$1,080.00

Note:

8/23/2017